

Date: Thursday, 20/11/2008 3:11:51 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	RH ACTUATOR ASSEMBLY	
<b>Job Number</b> :	43570			
<b>Estimate Number</b> :	12770			
<b>P.O. Number</b> :		<b>Part Number</b> :	41232 200 001 002	
<b>This Issue</b> :	20/11/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	41232-200-001 REV IR	
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	43287	<b>Drawing Revision</b> :	IR	
	<b>Type</b> :	<b>Material</b> :		
	SMALL /MED FAB	<b>Due Date</b> :	28/12/2008	<b>Qty:</b> 4 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	JLD 08.11.21			
<b>Comment</b> :	Est Rev:A New Issue 07-02-28 JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MS208224	elbow
-----	----------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

elbow

Batch: M110363

9/5/21

SD

2.0	AN8424D	Elbow
-----	---------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Elbow

Batch: M110139

9/5/21

SG

3.0	41232 200 007 001	Brass Cylinder Assembly
-----	-------------------	-------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Brass Cylinder Assembly

Batch: 43733

9/5/20

SG

4.0	41232 200 003 001	Spring (Step Actuator)
-----	-------------------	------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spring (Step Actuator)

Batch: B30941

9/5/21

SP

5.0	MS1699623	cap screw
-----	-----------	-----------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

cap screw

Batch: M103934

9/5/21

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43570

Part Number: 41232 200 001 002

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	AN3154R	Nut
-----	---------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M17566

9/15/21

SP

7.0	AN960JD416	Washer
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M111279

9/15/21

SP

8.0	AN960JD10	Washer
-----	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M111279

9/15/21

SP

9.0	MS21042L3	Nut
-----	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M110844

9/15/21

SP

10.0	AN322A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M106043

9/15/21

SP

11.0	41232 200 005 003	Spacer (Step Actuator)
------	-------------------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer (Step Actuator)

Batch: 1539218

9/15/21

SP

12.0	41232 200 002 005	pivot arm
------	-------------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pivot arm

Batch: 46701

9/15/21

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:11:51 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43570

Part Number: 41232 200 001 002

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 41232 200 002 003 latch



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

latch

Batch:

46703 1X B 3/3304 9/5/21

SP

14.0 41232 200 002 001 tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

tube

Batch:

45303

9/5/21

SD

15.0 41232 200 008 001 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Decal

Batch:

B 46687

9/6/12

16.0 S 1455 spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH:

M104079

9/5/21

(4x)

SP

17.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF 09-06-15

18.0 QCS INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/10/06/15 (4x) RH

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9/4/16

(4x)

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:11:51 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43570

Part Number: 41232 200 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/16 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

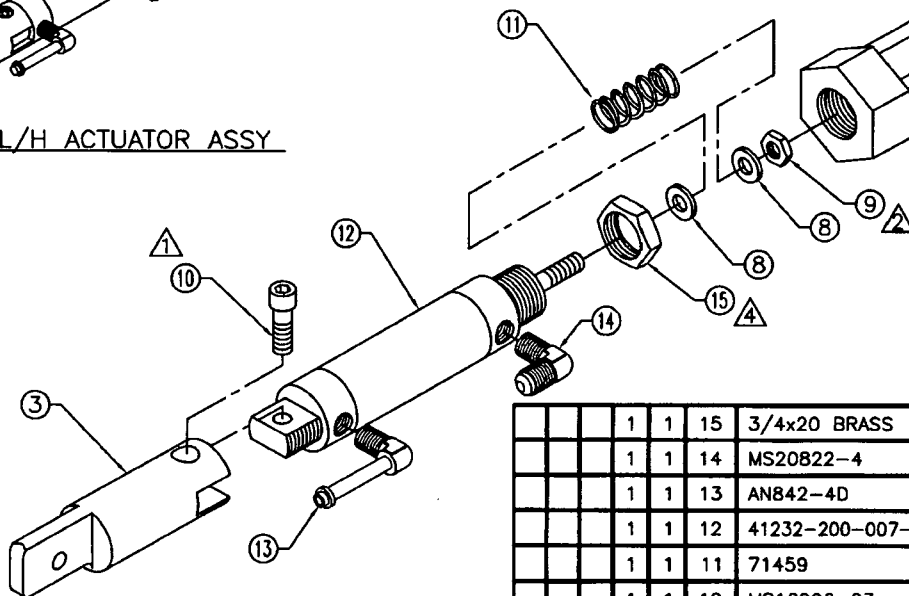
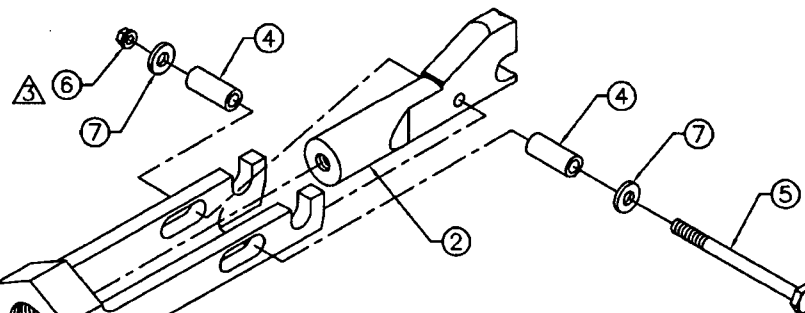
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

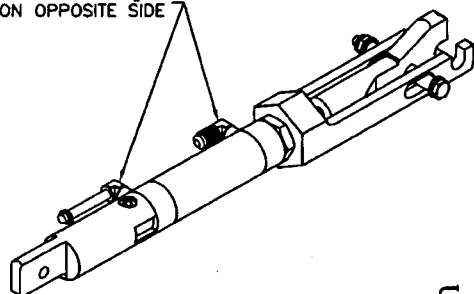
**NOTE:** Date & initial all entries







-001 L/H ACTUATOR ASSY



INSTALL ITEM #12  
ON OPPOSITE SIDE



-002 R/H ACTUATOR

-  TORQUE 80-100 IN.-LB.  
 TORQUE 20-25 IN.-LB.  
 TORQUE 50-75 IN.-LB.  
 TORQUE 50-75 IN.-LB.

NOTES:

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
No. 43570

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries